

Amendments to the Claims:

This listing of claims will replace all prior versions and listings of claims in the application:

Listing of Claims:

1. – 10. (canceled)

11. (new) A method of producing and filling a metal beverage container with dispensing opening and having an extended filled volume adjacent the dispensing opening, comprising:

forming a metal container sidewall by draw-and-iron process, wherein the sidewall is of predetermined maximum transverse dimension and has opposite first and second sidewall ends at predetermined first and second sidewall end lines;

forming a first endwall suited for attachment to said container sidewall at said first sidewall end thereof by seamed connection, configured such that said first endwall is substantially non-extending beyond the seamed connection when the first endwall is attached to the container sidewall, whereby the first endwall defines a stable resting surface when attached to the container sidewall and oriented as a bottom wall;

forming a second endwall configured with a peripheral extension wall and an end panel, wherein said extension wall is of smaller transverse dimension than said maximum transverse dimension of the container sidewall, configured with a pre-formed dispensing opening in said end panel at a position offset from a center of the end panel, wherein the second endwall is in communication with said container sidewall at said second sidewall end thereof such that the second endwall closes the second sidewall end, and the extension wall carries the end panel outside said second sidewall end line, thereby establishing an interior container volume including an expanded interior volume extending beyond the second sidewall end line;

applying a cap over said end panel, wherein said cap includes a central panel and a side skirt, the side skirt overlaps at least a portion of the extension wall, is rotatably engaged on the extension wall and is substantially non-removable from the extension wall;

providing a cap opening in said central panel in a suitable position to be moved with rotation of said cap between a registered and a non-registered position with respect to said pre-formed dispensing opening;

filling said container with a liquid contents through said first end with said first end upward;

after said filling step, applying said first endwall to the first sidewall end by seamed connection, establishing a filled beverage container; and

inverting said filled beverage container to rest on the first endwall as the container bottom wall and orienting said pre-formed dispensing opening and expanded interior volume at the top of the filled beverage container.

12. (new) The method of Claim 11, wherein:

said step of forming a second end wall comprises forming the second end wall as a one-piece structure with said container sidewall.

13. (new) The container of Claim 11, wherein said step of forming a second endwall comprises:

forming the second endwall suited for attachment to said container sidewall at said second sidewall end thereof by seamed connection; and

applying said second endwall to the first sidewall end by seamed connection, establishing a closed second end of container sidewall.